

Work Order ID 98123

98123

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March-07-13 12:59:46 PM

Item ID: D119-646-212
 Revision ID: ~~U/R~~ *N*
 Item Name: Skidtube STD w/ Training Wearplates, RH
 Start Date: 3/07/13 Start Qty: 1.00
 Required Date: 3/07/13 Req'd Qty: 1.00
 Reference: REWORK-ECN13-534

Accept

N900040100

Setup Start *NS1*
 Stop *NS2*

Approvals: Process Plan: *W* Date: Tooling: Date:
 QC: Date: SPC (Y/N): Date:

Run Start *NR1*
 Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|--------------|--------------|
| IIN-D119-646 | B |

100 0.00
 100
 DC Memo 0.00
 Document Control Photocopy bluefile & type labels per PPP D119-646-212
 CHG004 PER ECN 13-534

102 0.00
 102
 HandFinish Memo 0.00
 Hand Finishing PULL FROM STK:
 1 X D119-646-212 B93015
 REMOVE FWD CAP, PUT ASIDE TO RE-INSTALL

103 0.00
 103
 Skidtubes Memo 0.00
 Skidtubes COUNTERSINK FWD MOST HOLES TO
 0.385 X 100DEG ON BOTH SIDES
 PER DSI 9594
 DEBURR

Handwritten: JJC/MLS 13-3-12

| | | | |
|---|-----------------------|---|-----------|
| DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ONT CANADA K6A 1K7 | | TC APPROVAL #09-89 TEL: 1-613-632-5200 | |
| P/N | D119-646-212 | CHG | CHG003 |
| DESC | Skidtube STD, RH | SIC | SR02024SE |
| LOT | B93015 | SIC | |
| MODEL | Agusta A119/AW119MKII | SIC | |
| PATENTS: US #5735164, CA #2222180 EUROPEAN NO. #0828655 | | MADE IN CANADA | |

Handwritten: 1RH of JJC 13-05-11

Handwritten: DP 13-3-11

Handwritten: B98123 RH

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Item ID: D119-646-212

Accept

N900040100

Setup Start *NS1*

Revision ID: U/R

Stop *NS2*

Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 3/07/13 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 3/07/13 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference: REWORK-ECN13-534

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

| Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---------|--------|-----------|------------|------------|---------------|-------------|
|---------|--------|-----------|------------|------------|---------------|-------------|

104

QC5- Inspect part completeness to step on W/O

0.00

104

QC

Memo

Quality Control

0.00

105

0.00

105

HandFinish

Memo

Hand Finishing

- RE-ALODINE AFFECTED AREAS
- TOUCH UP WITH IMRON

0.00

106

QC3- Inspect Part Finish

0.00

106

QC

Memo

Quality Control

0.00

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98123

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Item ID: D119-646-212 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: U/R Stop ***NS2***
 Item Name: Skidtube STD w/ Training Wearplates, RH
 Start Date: 3/07/13 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 3/07/13 Req'd Qty: 1.00 ***1*** Customer:
 Reference: REWORK-ECN13-534

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 107 | | 0.00 | | | | | | | |
| *107* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | REPLACE FWD CAP USING MS24694-C52 SCREWS SIKAFLEX B <u>M123941</u> | | | | | | | | |
| 108 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *108* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 110 | Pick Kit | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | ENSURE ORIGINAL KIT IS IN BOX | | | | | | | | |

IRA 6 11 13/03/14

DAS
16
9-89 13/3/12

DAS
00
2-89

1 2 13-3/18

Work Order ID 98123***98123***

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Item ID: D119-646-212

Accept

N900040100Setup Start ***NS1***

Revision ID: U/R

Stop ***NS2***

Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 3/07/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 3/07/13 Req'd Qty: 1.00 ***1***

Customer:

Reference: REWORK-ECN13-534

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

SNP
13.320

1

130

0.00

130

Packaging

Memo

0.00

Packaging

RE-PACKAGE PER PPP USING NEW B/N
@ CHG 004
NEW LABELS AND DSI PAPERWORK REQ'D
Identify and pack for shipping as per PPP D119-646-212
Location: 032
PPP rev: C240
200
283
8 3/3/20

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MC 13-03-21

W130321

Picklist Print

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Work Order ID: 98123

Parent Item: D119-646-212

Start Date: 3/07/13

Required Date: 3/07/13

Parent Item Name: Skidtube STD w/ Training Wearplates, RH

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
644 DD verf:JLM IPP Rev:B 12.09.12 as per ECN12-
IPP REV:C 12.11.05 raise to chg003 (ECN 12-675) DD verf:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D119-646-212 | | Manufactured | No | | | | Each | 0.0000 | | 1 | 93015 | 3/03/13 | W |
| Skidtube STD w/ Training Wearplates, RH | | | | | | | | | | | | | |
| MS24694-C52 | | Purchased | No | | | | Each | 192.0000 | | 2 | 13/03/13 | | |
| Screw | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST301 | 192 | |
| 124291 | 92 | |
| 124308 | 100 | |

X2

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D119-646 REV. B, INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D119-646 REV. 1 OR EARLIER, REF. FAA STC SR02024SE

1.0 PURPOSE

The purpose of this DSI is to provide instructions for customers to modify the forward end of the D119-646-XXX skidtubes using the DSI 9594-011 Kit to make the skidtubes compatible with the Agusta ground handling wheels. One kit modifies 2 skidtubes. After CHG 001, portions of this modification may have been incorporated in production and therefore will not need to be incorporated in the field.

2.0 PROCEDURE

Modify the skidtubes as follows:


- 2.1 Rotate the D3407-041 Tow Ring to the vertical position as necessary.
- 2.2 Mark holes in the center ridge as shown in Figure 1. Drill through skidtube with Ø0.500" (12.7 mm drill), and countersunk to Ø0.650 x 100°, two places per side.
- 2.3 Remove and discard the hardware retaining the forward Cap. Countersink the existing holes to Ø0.385 x 100°.
- 2.4 Deburr holes. Touch up affected areas with chemical film material (Alodine 1200 or 1201) per MIL-C-5541.
- 2.5 Bond D2579 spacers into the Ø0.500 holes center in the skidtube using Magnobond 6398. Grind flush prior painting as shown in Figure 1.
- 2.6 Apply one coat of MIL-P-85582 or MIL-P-2337 primer and 2-3 coats of MIL-C-83285 polyurethane coat to match original finish.
- 2.7 Fasten the forward Cap using MS24694-C52 Screws. Seal threads with Proseal 890. Ensure that screw heads sit below skidtube surface
- 2.8 Repeat steps 2.1 to 2.7 for opposite skidtube.

3.0 PART LIST

| Qty -011 | PART NUMBER | DESCRIPTION |
|-------------|----------------|--------------------------------|
| X | DSI 9594-011 | FWD GROUND HANDLING SPACER KIT |
| 4 | D2579 | CROSS BOLT SPACER |
| 4 | MS24694-C52 | SCREW |

4.0 WEIGHT AND BALANCE

This modification has negligible effect on weight and balance.

| | | | |
|------------|--|---|--------------|
| B | ADD INSTRUCTION TO REMOVE EXISTING CAP MOUNTING HARDWARE AND REPLACE WITH COUNTERSUNK SCREWS | DB | 13.02.20 |
| A | NEW ISSUE | RF | 12.02.03 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | RF | DART AEROSPACE USA, INC. KENT, WA | |
| DRAWN | DB | | |
| CHECKED | MB | DRAWING NO. | REV. B |
| MFG. APPR. | N/A | DSI 9594 | SHEET 1 OF 2 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. | | FWD GROUND HANDLING SPACER KIT | NTS |
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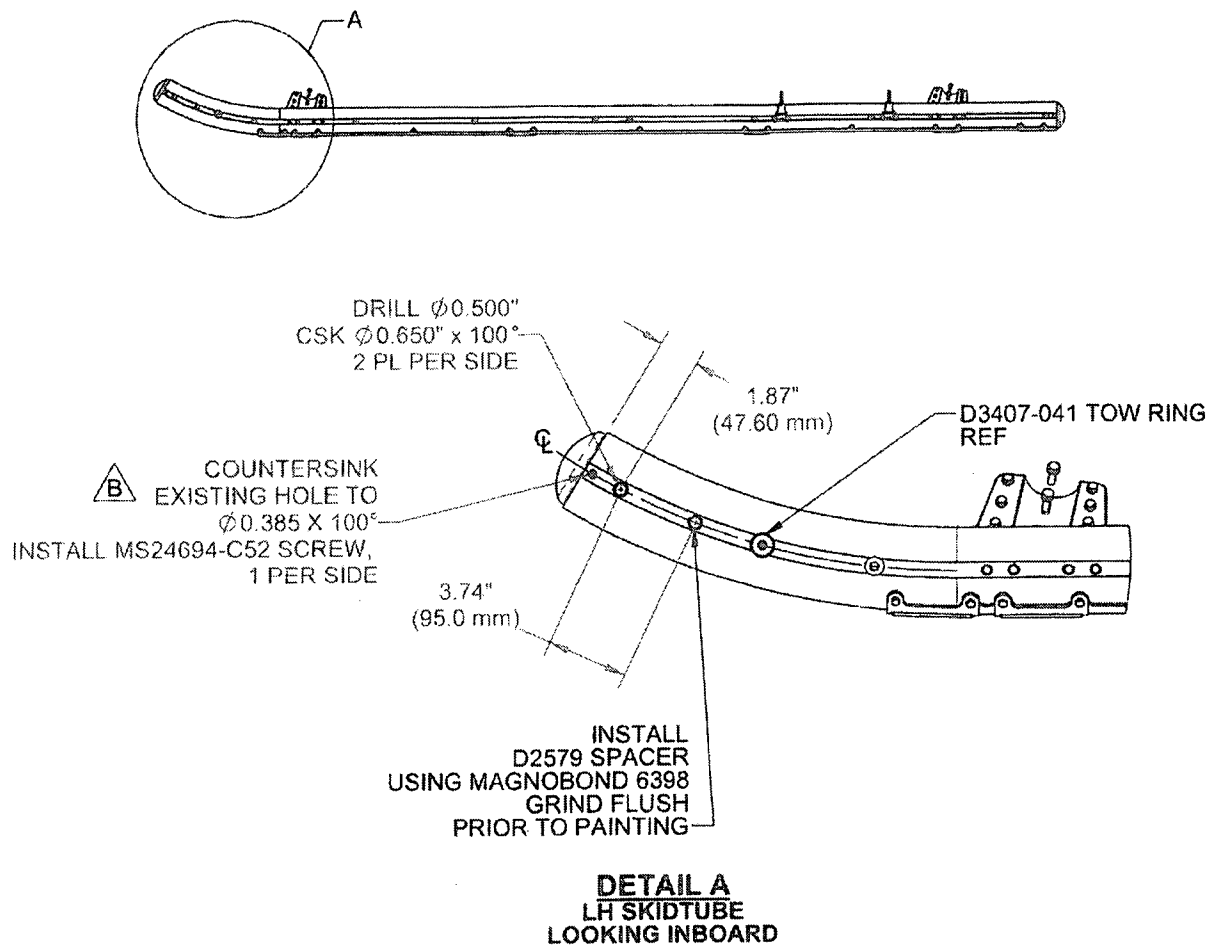


FIGURE 1. MODIFIED D119-646-XXX SKIDTUBE

| | | | |
|------------|--------------------|---|--------------|
| DESIGN | RF | DART AEROSPACE USA, INC | |
| DRAWN | DB | KENT, WA | |
| CHECKED | MB | DRAWING NO. | REV. B |
| MFG. APPR. | N/A | DSI 9594 | SHEET 2 OF 2 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | | FWD GROUND HANDLING SPACER KIT | NTS |
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Linda Lacelle

From: Mike Petsche
Sent: March-06-13 10:27 AM
To: Linda Lacelle; David Shepherd
Cc: Eric Downing
Subject: RE: 119 skids

Yeah that's pretty much the gist of it. The DSI had been for A-W to do the mod for the aircraft that is here at the show. But for any stock/WIP you have, do exactly what you just said.

Dave (Bain) has updated the dwgs. An ECN should not be terribly far off. (I'm checking with him now to see where it is)

From: Linda Lacelle
Sent: Wednesday, March 06, 2013 7:36 AM
To: David Shepherd
Cc: Mike Petsche; Eric Downing
Subject: RE: 119 skids

Thx David. I'm a bit confused though, this DSI is for the customer when in the field correct? All we have to do is countersink the holes for the cap, re-alodine, touch up, replace cap with screw, correct?
LL

From: David Shepherd
Sent: March-05-13 2:32 AM
To: Mike Petsche; Linda Lacelle
Subject: RE: 119 skids

ECN B-534

Linda,

I am good with modifying the front end of the 119 skidtubes to the attached DSI.

Regards,
David

From: Mike Petsche
Sent: March-04-13 10:17 AM
To: Linda Lacelle; David Shepherd
Subject: FW: 119 skids

fyi

From: David Bain
Sent: Monday, March 04, 2013 12:06 PM
To: Mike Petsche
Subject: RE: 119 skids

Mike,

new work up
- 98121 > 91
- 98122 > 91
- 211 x 2 sth
wip > 93010 94837
93011
93012
93013
93014
- 212 x 3 sth
wip > 91627
93016 93019
93017
93018
new work
98123 > 91
98124 > 91
98125
98126 > 91